

Work Order ID 82115

March-23-12 10:43:01 AM

82115

Page 1

Item ID: D3762-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fitting

Start Date: 22/03/2012 Start Qty: 11.00

11

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 11.00

11

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/23

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3762

Rev A

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA748 Rev: ML & Dwg D3762 Rev: 1
2-Deburr per dwg D3762

SL 12/4/11

16 φ

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 12/4/11

16 φ

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 12/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82115

March-23-12 10:43:01 AM

82115

Page 2

Item ID: D3762-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fitting
 Start Date: 22/03/2012 Start Qty: 11.00 ***11*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 11.00 ***11*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(16)

12/4/16

12/4/17

mf
12-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-23-12 10:43:05 AM

Page 1

Work Order ID: 82115

82115

Parent Item: D3762-1

D3762-1

Parent Item Name: Fitting

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 11.00

Required Qty: 11.00

Comments: IPP Rev:A 08-05-23 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000		Purchased	No			100	f	44.5030	0.16	1.852632			

M6061T6R1 000

ROUND BAR 1.00"

**

SA 12/4/11

Location

Loc Qty

Loc Code

MAT008

24

121070

24

MAT013

20.503

116406

14.303

118271

6.2

121192

2.6 ft

W/O:		WORK ORDER CHANGES					
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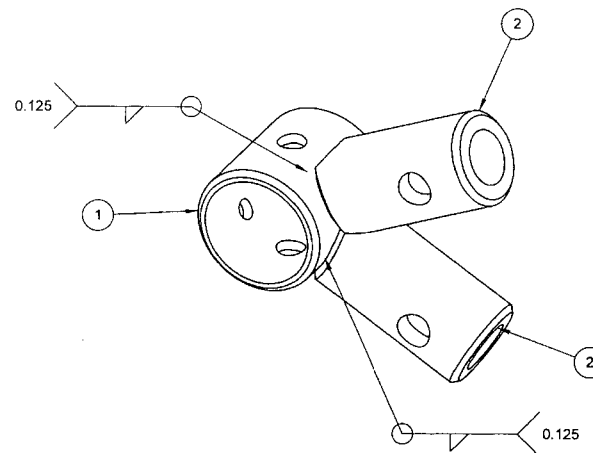
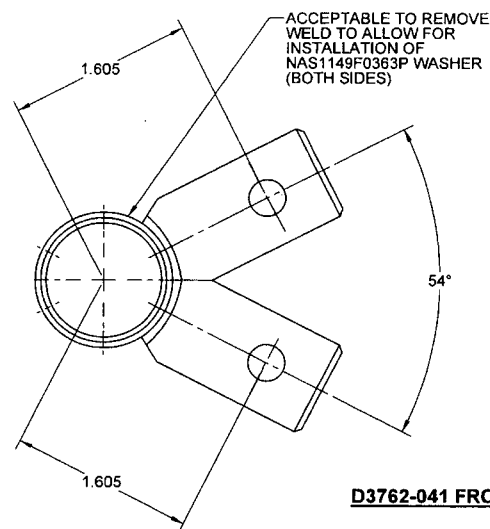
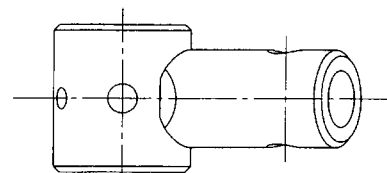
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82115 MCT
12/03/23



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3762-3	TUBE	1
2	D3762-1	FITTING	2

RELEASED
08-06-04

D3762-041 FRONT LEG FITTING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

A		NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION			BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	HS				
CHECKED	HS	DRAWING NO.	REV. A		
MFG. APPR.	HS	D3762	SHEET 1 OF 3		
APPROVED	HS	TITLE	SCALE		
DE APPR.	HS	FRONT LEG FITTING	NTS		
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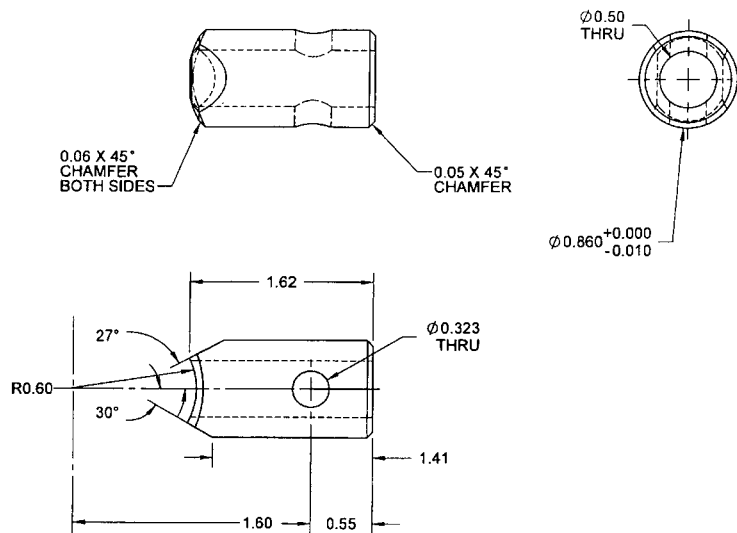
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

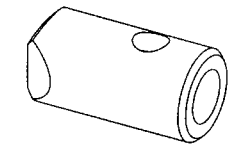
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NOTE: Date & initial all entries



D3762-1 FITTING



82115

RELEASED
108.06.16

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

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CHECKED	<i>HS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>HS</i>	D3762	SHEET 2 OF 3
APPROVED	<i>HS</i>	TITLE	SCALE
DE APPR.	<i>HS</i>	FRONT LEG FITTING	NTS
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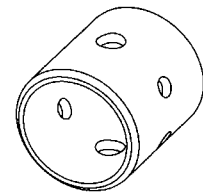
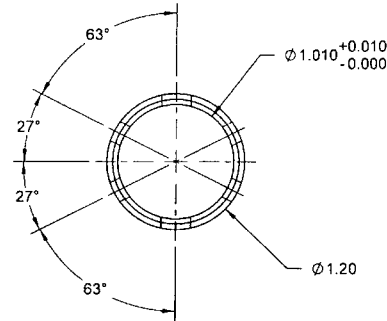
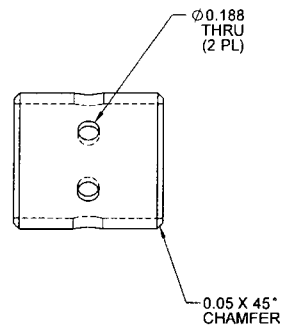
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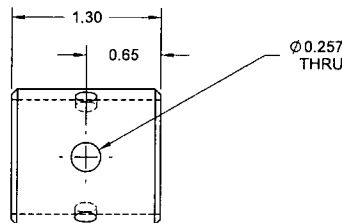
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NOTE: Date & initial all entries



82115



D3762-3 TUBE

RELEASED
08-06-16/17

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	HS	D3762	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	FRONT LEG FITTING	NTS
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